38

9-89

OCT 2 2 2014

Work Order ID 125493 \*125493\* Page 1 Thursday, October 09, 2014 12:39:37 PM Item ID: D3650-5 Accept \*N900040100\* Setup Start **Revision ID:** Stop **Item Name:** Fwd Panel \*4\* **Start Date:** 10/9/2014 Start Oty: 4.00 **Cust Item ID: Required Date: 10/9/2014** Reg'd Oty: 4.00 \*4\* **Customer:** Reference: Run Start Process Plan: Date: 14-10-09 **Tooling:** Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Set Up/ Tool # Plan Accept Reject Reject Insp. **Work Center ID Description** Run Hours Code Qty **Qty** Number Stamp Draw Nbr **Revision Nbr** D3650 Rev E 100 . DAS 0.00 23 FLOW WATER JET \*100\* 14-10-22 Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg D3650 Dwg Rev: Prog Rev: 2-Deburr if necessary DAS 110 QC2- Inspect parts off machine FAI/FAIB 0.00 23 \*110\* 14-10-22 QC 0.00 Memo Quality Control DAS 120

0.00

0.00

QC8- Inspect parts - second check

Memo

\*120\*

Quality Control

QC

DQA:	<del></del>		Date:			WORK ORDER NON	-C0	ONFOI	RMANCE / LI	PNATE			DART
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	QC:		Date:	<b>SPC</b> (Y/N):	<b>D</b> :	ate:				Stop	*N	R2*
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Brake NC  140  ★1 △∩*  QC		Form as per  QC5- Inspect part compl		0.00	·			(4)				DAS 38 9-89
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Work Orde Thursday, Octob				*125	5493*							Page (	3
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170 <b>*17</b> Packaging  Packaging		Identify as per dwg & Sto	ock Location: <b>SF276</b>	0.00 0.00				9				NOV 0	DAS <b>46</b> 9-89 7 2014

180

Packaging

QC21- Final Inspection - Work Order Release

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\*120\*

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7	Thursday, October 0	9, 2014 12:3	9:36 P	PM .											Page 1
7	Work Order ID: 125	5493			*-	12549	);3*								-
I	Parent Item: D3	650-5				D3650									,
I	Parent Item Name:	Fwd Panel			•	20 10 10 10				S	tart Date: 10	0/9/2014	Required	<b>d Date:</b> 10/	9/2014
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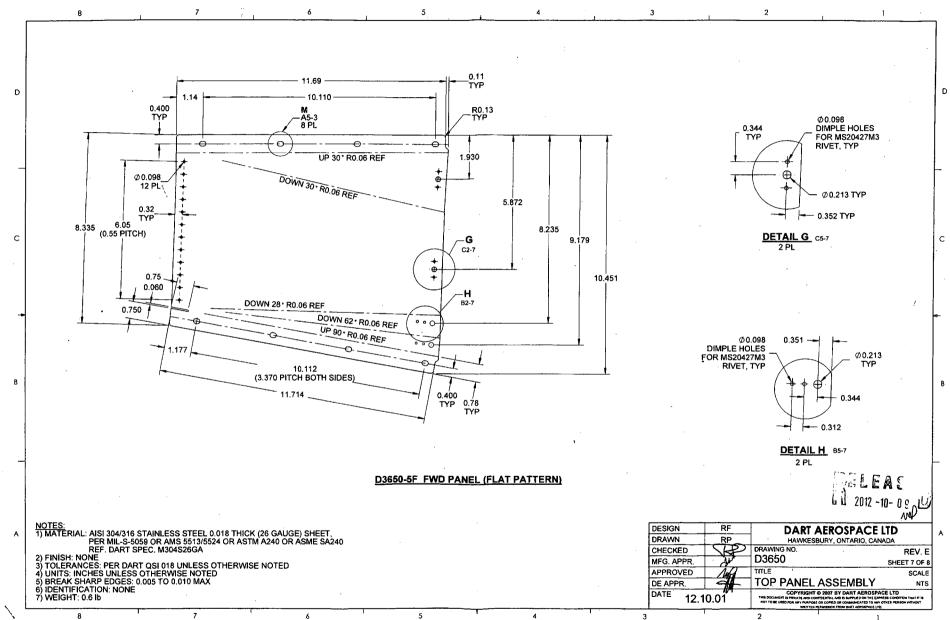
Picklist Print Thursday, October 09, 2014 12:39:3	37 PM									Page 2
Work Order ID: 125493  Parent Item: D3650-5  Parent Item Name: Fwd Panel			25493* )3650-5*				art Date: 1 tart Qty: 4		Required Da Required Qt	
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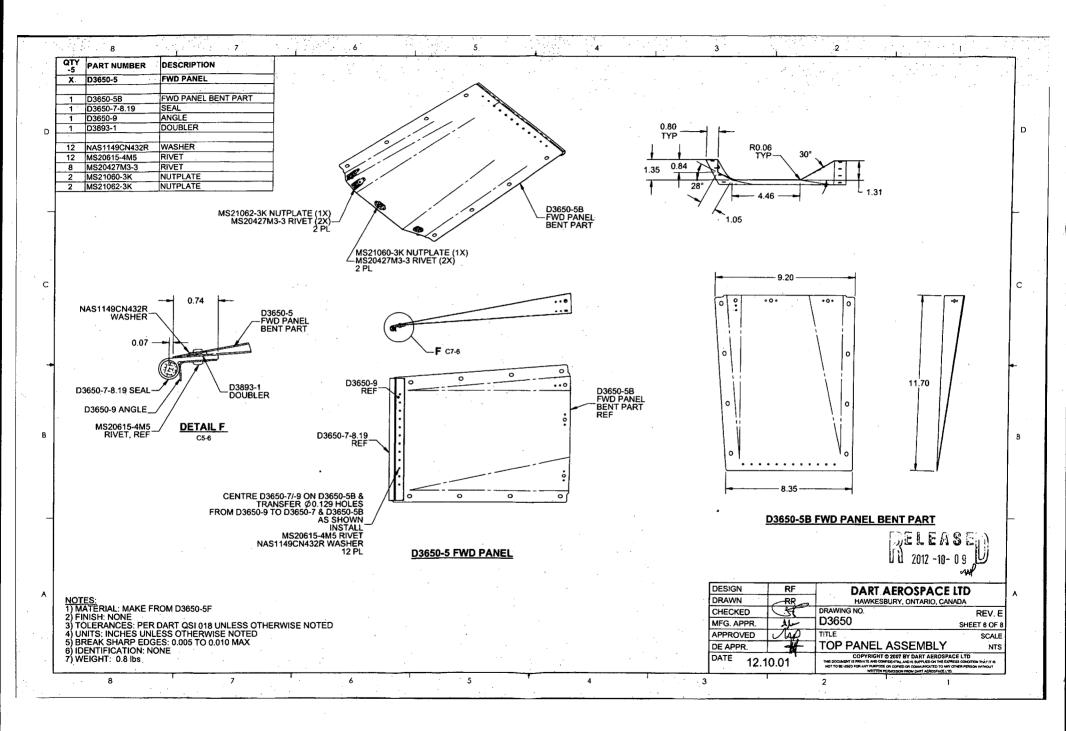
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Page 2

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	Wa	ve/Twi	st in Tub	e	1	Fit/Function		Out of S	Sequence				·

DART AEROSPACE LTD	Work Order:	
Description: Fwd Panel	Part Number:	D3650-5
Inspection Dwg: D3650 Rev: E		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.099	-		U	Jamo;
Ø0.213	+0.005/-0.001	0.215	_		V	
0.400	+/-0.010	G-400"	_		٧	
1.173	+/-0.010	1.173	_		ν	
11.714	+/-0.010	11314			٧	Jkmvo
10.112	+/-0.010	10:112	_		V	
5.872	+/-0.010	5.873`	_		V	
1.930	+/-0.010	1.930	_		ν	
8.235	+/-0.010	9.735			٧	
9.179	+/-0.010	9.179	1		ν	
10.451	+/-0.010	10,451	-		· >	
11.694	+/-0.010	11.694"	_		J	
1.14	+/-0.030	1.14			J	
8.335	+/-0.010	8/335	•		ν	
0.213	+/-0.010	0213	-		ν	
0.276	+/-0.010	6.276	_		V	
			_			
	DAS		⊓DASS			

_		DAO .		388		
	Measured by:	<b>23</b> 9-89	Audited by:	9-639	Preliminary Approval:	
	Date:	14-10-22	Date:	OCT 2 2 2014	Date:	

Rev Date		Change	Revised by	Approved		
Α	08.04.17	New Issue	KJ/DD			
В	12.09.26	Dimensions updated per Dwg Rev D	KJ IX			
С	13.02.27	Dwg Rev updated	KJ 9X	_ M		
			717	•		

DQA: Date:				- WORK ORDER NON CONFORMANCE (LIRDATE										
QA Closed: Date:					• •	WORK ORDER NON-CONFORMANCE / UPDATE  Work Order update only  Work Order update only								AEROSPACE
Work Order:				DISPOSITION AGAINST			AGAINST I	T DEPARTMENT/PROCESS						
Part No					<del></del>	Rework Scrap Use-as-is Suspected Unapproved		Machining Small Fab Thermoforming Finishing		Crosstube Small Fab Finishing Composite	Prod. Eng. Coor.  Rec/Store/Packaging			Engineering Quality Other
Root					Desc	ription of work order update		Initial	Ac.	tion	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	hief Eng Description		ription '	Date	Verification	n	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved														
			l	l	l		FA	ULT CAT	EGORY		I			
Landi	ng (	Gear				General							•	
	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence					Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Folio/Program Grain Hardware Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off center Mislabeled Misread Off-set Out of Calibration			Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong			ressure/Forced et-up emperature/Cure Veld Vrong Stock Pulled
	Wave/Twist in Tube					Fit/Function		Out of S	iequence					

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH